

**Work Order ID 62803**

Friday, October 08, 2010 10:37:06 AM



Page 1

Item ID: D4092-042

Accept



Setup Start



Revision ID:

Item Name: Maintenance Step Assembly

Stop



Start Date: 10/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/10/08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4092    | A            |

100



Packaging

Pick Kit

0.00

10/10/08 ①

Packaging

Memo

0.00

110



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in-lbs

0.00

10/11/08 ①

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

Initials "to be signed"  
nec

Quality Control

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

① \_\_\_\_\_

(P70)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: Smooth finish NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: re-work Disposition: re-work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |  |                 |                           |                       |                          |
|----------|------|--|-----------------------------|--|-----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B |  |                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date  |                           |                       |                          |
| 10/11/15 | 110  | D4693-1 & -3 Brackets<br>(-1, B62563 & -3 B62567)<br>have water jet chatter along<br>the parts. Chatter was caused<br>by the process. But parts should<br>have been reworked smooth.<br>RC: LACK OF ATTENTION. | <u>QSI0412</u>              | <ul style="list-style-type: none"> <li>- re-work the -1 &amp; -3 Brackets<br/>to remove the chatter marks.</li> <li>Ensure thickness's are still<br/>in accordance to the drawing.</li> </ul> <p>QC S inspect Finish</p> | <u>10/11/15</u> | <u>QSI0412</u>            | <u>10/11/15</u>       | <u>10/11/15</u>          |
|          |      |  | <u>QSI0412</u>              | <ul style="list-style-type: none"> <li>- Touch-up areas with lacquer<br/>&amp; re-powder coat white.</li> </ul> <p>Start: <u>9:30</u> Batch M115291<br/>Finish: <u>3:20</u> Temp: <u>10:00</u></p>                       | <u>10/11/16</u> | <u>S</u>                  | <u>QSI0412</u>        | <u>10/11/15</u>          |
|          |      |  | <u>QSI0412</u>              | <ul style="list-style-type: none"> <li>- Re-assemble step pending</li> </ul>   | <u>10/11/17</u> | <u>S</u>                  | <u>QSI0412</u>        | <u>10/11/15</u>          |

NOTE: Date & initial all entries

**Work Order ID 62803**

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Page 2

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

130



Packaging

Packaging

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInspec.  
Stamp

Identify as per dwg &amp; Stock Location:

0.00

Memo

PPP  
6307

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10.11.18 test only  
 - with approved drawings D4093-5 62569  
 - D4092-1 Rev PB1 63047  
 U 10.11.18



**Picklist Print**

Page 1

Friday, October 08, 2010 10:37:10 AM

**Work Order ID:** 62803**Parent Item:** D4092-042**Parent Item Name:** Maintenance Step Assembly**Start Date:** 10/8/2010**Required Date:** 10/15/2010**Start Qty:** 1.00**Required Qty:** 1.00**Comments:** IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued    | Date<br>Issued  | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|------------------|-----------------|--------|
| D4092-1<br>                     |                        | Manufactured  |             | No                  |                  |                 | Each               | 0.0000         | 2           |              | <i>625011/03</i> |                 |        |
| Maintenance Step<br>            |                        | Manufactured  |             | No                  |                  |                 | Each               | 0.0000         | 1           |              | <i>62565</i>     | <i>62565</i>    |        |
| Bracket<br>                     |                        | Manufactured  |             | No                  |                  |                 | Each               | 0.0000         | 1           |              | <i>62567</i>     | <i>62567</i>    |        |
| Bracket<br>                     |                        | Manufactured  |             | No                  |                  |                 | Each               | 0.0000         | 2           |              | <i>6259</i>      | <i>6259</i>     |        |
| Bracket<br>                     |                        | Manufactured  |             | No                  |                  |                 | Each               | 0.0000         | 2           |              | <i>62622</i>     | <i>62622</i>    |        |
| MS24694-S54<br>                 |                        | Purchased     |             | No                  |                  |                 | Each               | 72.0000        | 2           |              | <i>11/16/22</i>  | <i>11/16/22</i> |        |
| Screw<br>                       |                        |               |             |                     |                  |                 |                    |                |             |              |                  |                 |        |

LocationST289  
113359  
115531Loc Qty

72

1

71

Loc Code

MS24694-S55



Screw

Purchased

No

Each

77.0000

LocationST289A  
13884Loc Qty

77

77

Loc Code

# Picklist Print

Page 2

Friday, October 08, 2010 10:37:10 AM

Work Order ID: 62803



Parent Item: D4092-042



Parent Item Name: Maintenance Step Assembly

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00 2

Required Qty: 1.00

MS24694-S56



Purchased

No

Each

110.0000

2



SCREW

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST289A          | 110            |                 |
| 104407          | 110            |                 |

NAS1149D0332J



Purchased

No

Each

603.0000

12



Washer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST298           | 603            |                 |
| 110985          | 12             |                 |
| 114348          | 126            |                 |
| 114884          | 265            |                 |
| 114962          | 200            |                 |

MS21042L3



Purchased

No

Each

2,546.000

12

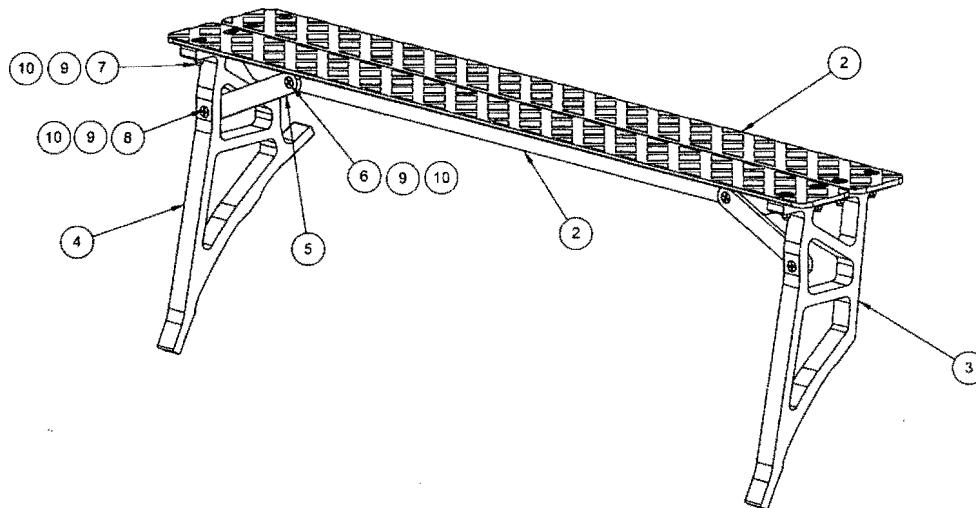


Nut

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST300           | 2546           |                 |
| 114523          | 49             |                 |
| 114784          | 1497           |                 |
| 115835          | 1000           |                 |

8 7 6 5 4 3 2 1

| ITEM | QTY | PART NUMBER   | DESCRIPTION            |
|------|-----|---------------|------------------------|
| 1    | X   | D4092-041     | MAINTENANCE STEP ASS'Y |
| 2    | 2   | D4092-1       | MAINTENANCE STEP       |
| 3    | 1   | D4093-1       | BRACKET                |
| 4    | 1   | D4093-3       | BRACKET                |
| 5    | 2   | D4093-5       | BRACE                  |
| 6    | 2   | MS24694-S54   | SCREW                  |
| 7    | 8   | MS24694-S55   | SCREW                  |
| 8    | 2   | MS24694-S56   | SCREW                  |
| 9    | 12  | NAS1149D0332J | WASHER                 |
| 10   | 12  | MS21042L3     | NUT                    |



D4092-041 MAINTENANCE STEP ASS'Y

STOKE  
PULL  
PUSH  
UNCOUPLED  
SUSPENDED

NO. 62803  
B7101008

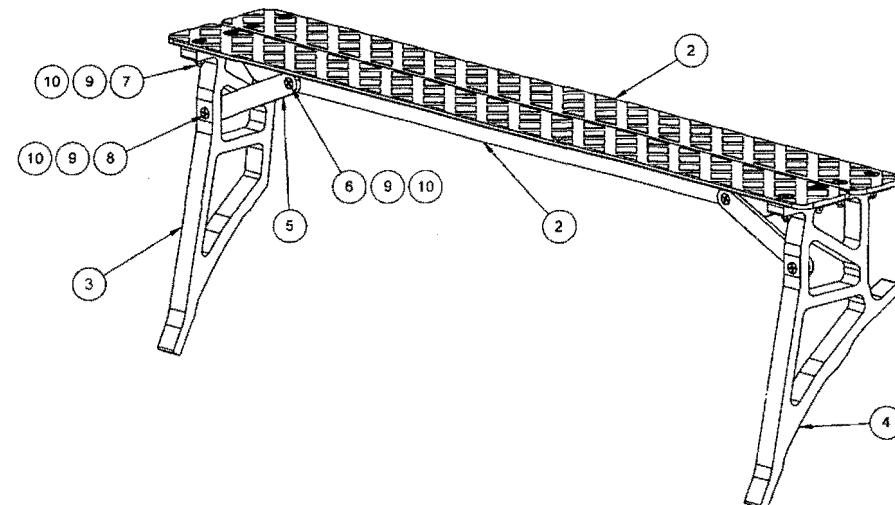
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

| ITEM | QTY | PART NUMBER   | DESCRIPTION            |
|------|-----|---------------|------------------------|
| 1    | X   | D4092-042     | MAINTENANCE STEP ASS'Y |
| 2    | 2   | D4092-1       | MAINTENANCE STEP       |
| 3    | 1   | D4093-1       | BRACKET                |
| 4    | 1   | D4093-3       | BRACKET                |
| 5    | 2   | D4093-5       | BRACE                  |
| 6    | 2   | MS24694-S54   | SCREW                  |
| 7    | 8   | MS24694-S55   | SCREW                  |
| 8    | 2   | MS24694-S56   | SCREW                  |
| 9    | 12  | NAS1149D0332J | WASHER                 |
| 10   | 12  | MS21042L3     | NUT                    |



w/o 42803

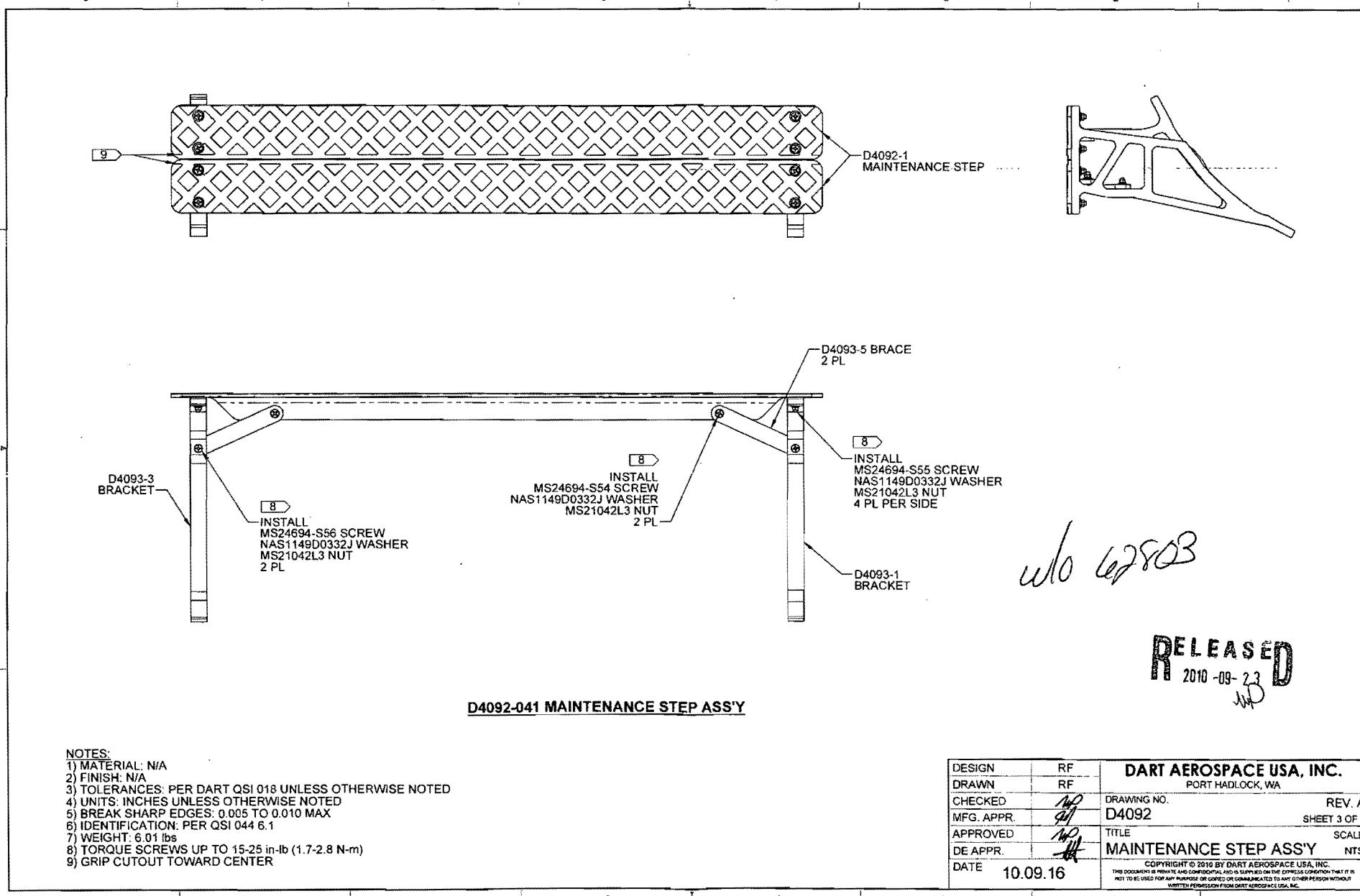
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|            |          | NTS                             |

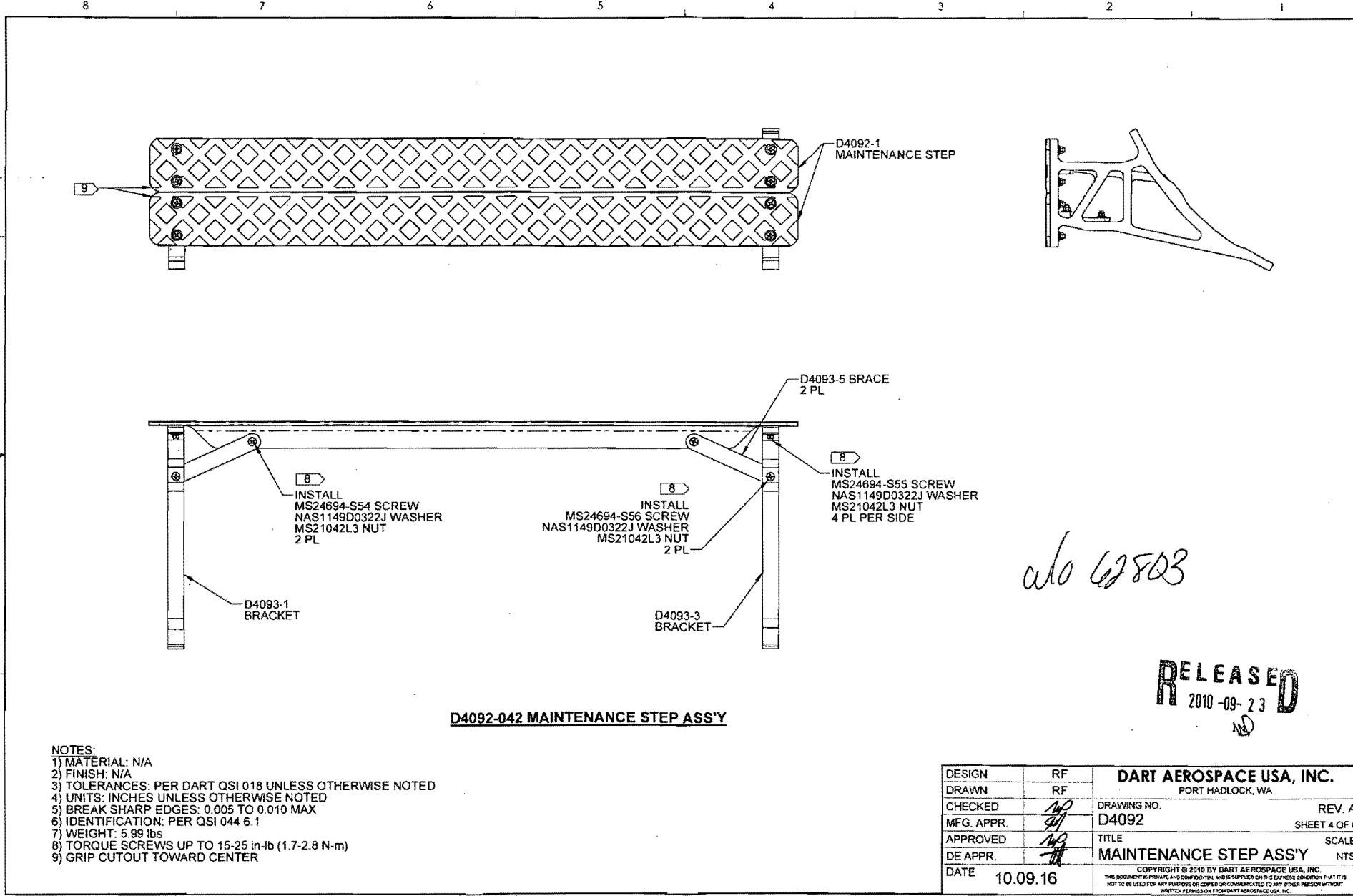
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